Work Ord November-30-12	,	3 -			/*9	<u>403</u>	4*							Page 1
Item ID: Revision ID:	D4016-1				Accept	*	N 900	040	100)*	Setup	Start Stop	1 71	S1*
Item Name: Start Date: Required Date: Reference:	Hinge Half, 1 12/24/12 : 12/24/12	Base Start Qty: Req'd Qty:		*2* *2*			Cust Item I Customer:	D:				Stop	*N	S2*
Approvals:	Process P	lan: ML3		te: <u>12-12-</u> te:	©3Tooling:SPC (Y/N)	-		ate:			Run	Start Stop	171	R1* R2*
Sequence ID/ Work Center I		Operation Description			Set Up/ Run Ho		Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Re	evision Nbr												
D4016	Α													
100		Cut blanks as a	per folio		0.00		24							
100 Bandsaw Jeaspa Bandsaw			emo UT BLANK 1.00	" LONG	0.00	JL 16	2-12-10			2				
110		•			0.00		· www.				Ψ,			DAS
110 HAAS I		М	lemo		0.00					(2))			8-89 /

DEBURR

HAAS CNC vertical machine #1

								DQA:	Date:	
NCR: Yes	s / No			WORK ORDER NON-	CONFOR	MANCE / U		QA Closed:	Date:	
Work Order:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.				Rework Scrap Use-as-is Work Order Update	I	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Description of work order update	Initial	Δ	Action	Sign &		
Cause	Date	Step	Qty	or Non-conformance	Chief Eng	Des	scription	Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling]							,		
Operator		•								
Material								•		
Setup		1								
Other							•			
Process										
Supplier]									
Training									1	
Unapproved	<u> </u>		,-							
					FAULT CATE	GORY				
Landing	Gear			General						

u	י סי	2CG1	 - Cinciui			 _
		Bending	Bend	Grain	Ovalized	Pressure/Forced
		Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure
		Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld
		Crushed/Crimped	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
		Cuffs	Contamination	Maintenance	Part Moved	
		Heat Treat	Countersink	Mislabeled	Positioned Wrong	_
		Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge	Other
[Ripples in Bend	Drill Holes	Offset		
[Torque Waves in Extrusion	Drawing	Out of Calibration		
		Turning Sequence	Finish	Out of Sequence		
		Wave/Twist in Tube	Folio	Outside Dimensions		

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Work Orde November-30-12				*94	034*					_	Page 2
Revision ID:	D4016-1		• • • • • • • • • • • • • • • • • • •	Accept	*N900	040	100)* s	etup Star Stop	i Vi	S1*
	Hinge Half, Ba 12/24/12 12/24/12	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:			•	"IN	S2*
Approvals:		in:				ate:		R	tun Star Stop		R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*120 *120* QC Quality Control		QC2- Inspect parts off m	achine FAI/FAIB	0.00							25 D-D-
130 *130* QC Quality Control		QC8- Inspect parts - seco	ond check	0.00	m 2/12/	19		2	_JE		·
160 *160* Packaging		Identify as per dwg & St	tock Location	0.00				-2x			~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~

Packaging

												DQA:	Dat	e.	
NCR:	Yes	/ No				WORK ORDER NON-O	100	NFOR	MANCE / UP	DATE				-	
												QA Closed:	Dat	e:	
Work Ord	or:					DISPOSITION				AGAINST	DE	PARTMENT	PROCESS		
work Ord	ег.					Rework	1		Skid-tube	Crosstube		1	Water Jet	\neg	Engineering
Part l	Vo.					Scrap	1 1	!	Machining	Small Fab	_	l Pro	d. Eng. Coor.	ㅓ	Quality
						Use-as-is	1		noforming	Finishing		1	e/Packaging	\dashv	Other
NCR	No.					Work Order Update	1		Large Fab	Composite		1	Supplier		
										•	_	-			
Root					Descri	ption of work order update	1	Initial	Ac	tion		Sign &	÷		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification		QC Inspector
Doc/Data									-						
Equip/Tooling														- 1	
Operator															
Material															
Setup														}	
Other															
Process												ŀ			
Supplier							İ							ļ	
Training															
Unapproved															
						F	AUL	T CATE	GORY						
Landi	ng (Gear				General		•				_			•
	L	Bending				Bend		Grain			L	Ovalized		<u> </u>	Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance	<u> </u>	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete			Part Incorre	ct [Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/	'Unclear		Part Lost/M	ssing	ĺ	Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Work Ord November-30-12				*940)34*							Page 3
Item ID: Revision ID: Item Name:	D4016-1 Hinge Half,	Base		Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	12/24/12	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:						
Approvals:	Process P QC:	lan:	Date:	Tooling:SPC (Y/N):		nte:			Run	Start Stop	1/7	R1* R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept	t Re Qt		Reject Number	Insp. Stamp
170 *170* QC Quality Control		QC21- Final Inspection	- Work Order Release	0.00						13) [. M. F	10 \$

												DQA:	Date	e: _	
NCR:	Yes	/ No				WORK ORDER NON-	COI	VFORN	/IANCE / UP	DATE		·		_	
						,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,						QA Closed:	Date	<u>:</u> :	
Work Ord	or.					DISPOSITION				AGAINST D	ΕI	PARTMENT	PROCESS		
Work Ord	٠					Rework	۱ ۱		Skid-tube	Crosstube	7		Water Jet	\neg	Engineering
Part !	No.					Scrap	1		Machining	Small Fab	7	Pro	d. Eng. Coor.	\dashv	Quality
	•					Use-as-is	1		oforming	Finishing	٦	Rec/Stor	e/Packaging	٦	Other
NCR I	No.					Work Order Update			Large Fab	Composite			Supplier		
Root					Descri	otion of work order update	T i	nitial	Δι	ction	_	Sign &		\exists	
Cause		Date	Step	Qty		or Non-conformance		ief Eng		cription		Date	Verification		QC Inspector
Doc/Data	П		Step				1				_			1	
Equip/Tooling	П														
Operator	П														
Material								Į							
Setup ·														-	
Other	П														
Process	П														
Supplier	П														
Training														ı	
Unapproved	П						1							ı	
				•		F	AUI	T CATE	GORY						
Landi	ing (ear				General		_							
		Bending				Bend		Grain				Ovalized			Pressure/Forced
		Centre N	ot Conce	ntric to C)/S	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incorre	ct		Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete,	/Unclear [Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination]Mainte	nance			Part Moved			
		Heat Trea	at			Countersink] Mislabe	led			Positioned V	Vrong _		
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	l			Power Loss/	Surge		Other
		Ripples ir	n Bend			Drill Holes		Offset		_		_	_		

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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Page 1

Work Order ID:

94034

Parent Item:

D4016-1

Parent Item Name:

Hinge Half, Base

Start Date: 12/24/12

Required Date: 12/24/12

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY :DD 10.02.22 verified by:FC

IPP Rev:B as per dwg REV.A DD

	10.02.22 Verified (by.cc											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.000X1.000		Purchased	No			100	f	16.8340	0.08	0.16	W E	اعدا ع	G
304 bar 1.00 x 1.00	· ·						.	C 1	e		O LAKE		V

Location	Loc Qty	Loc Code	
MAT050	16.834		
113290	1.047		
121806	4.647		
122008	11.14		-16

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-O	CON	NFORN	AANCE / UP	DATE			
											QA Closed:	Date:	
Work Ord	or:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
VVOIR OIG	CI.					Rework	7		Skid-tube	Crosstube]	Water Jet	Engineering
Part	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
,						Use-as-is	1		noforming	Finishing	4	re/Packaging	Other
NCR	No.					Work Order Update			Large Fab	Composite		Supplier	
Root					ł	ption of work order update	1	nitial		tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data	<u></u>									-			
Equip/Tooling													
Operator													
Material					7								
Setup					•				₹*		,		
Other													
Process													
Supplier	Ш												
Training													
Unapproved			<u>l</u>				<u> </u>				<u> </u>		
							AUL	T CATE	GORY	·			
Land	ing (1				General		1 .		r	٦		1
	_	Bending				Bend		Grain			Ovalized		Pressure/Forced
	<u> </u>	Centre N	ot Concer	ntric to	o/s	BOM/Route	_	Hardwa			Over/Under	 	Temperature/Cure
	<u></u>	Cracks			<u> </u>	Broken/Damaged	_	4 '	on Incomplete	_	Part Incorre	—	Weld
	<u>_</u>	Crushed/	Crimped.		<u></u>	Burrs	<u> </u>		ions Incomplete/	'Unclear	Part Lost/M		Wrong Stock Pulled
		Cuffs			<u> </u>	Contamination		Mainte			Part Moved		
		Heat Trea	at			Countersink	\perp	Mislabe	led		Positioned \		-
ĺ	1	Inspectio	n Strip in	Tube		Cut Too Short		Misread	l		Power Loss,	/Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Cut Too Short Drill Holes

Drawing

Finish

Folio

DART AEROSPACE LTD	Work Order:	94034
Description: Hinge Half, Base	Part Number:	D4016-1
Inspection Dwg: D4016 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.875	+/-0.010	872			16th S1-10	
0.25	+/-0.030	241				
0.38	+0.030/-0.000	-388				
R0.03	+/-0.030	-032				
0.13	+/-0.030	-125				
0.88	+/-0.030	.875				
Ø0.257	+0.006/-0.001	257				
R0.38	+/-0.030	345				
0.500	+/-0.030	.500				
0.75	+/-0.030	.750				

Measured by:		Audited by:	and	Preliminary Approval:	
Date:	12-12-19	Date:	12/12/19	Date:	

Rev	Date	Change	Revised	þ <u>/</u> X	Approved
Α	10.06.07	New Issue	KJ <	K	
				r/)	•

SHOET OUT RELEWS OF ENGINEERING

UNCONTROLL TO COPY

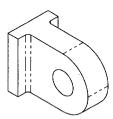
SUBJECT TO A Michigan VI

WEBGCCOOL

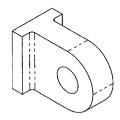
WORK CLOPR NO 94034MLT

12-12-03

D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

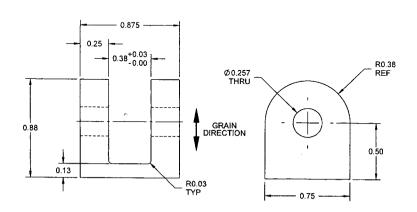


D4016-5 HINGE HALF, LIGHT LID

Α	NEWISSUE				10.01.29		
REV.			DESCRIPTION	BY	DATE		
DESIG	V	AJS	DART AEROSPACE LTD				
DRAW	DRAWN AJS		HAWKESBURY, ONTARIO, CANADA				
CHECKED (7) MFG. APPR.		an	DRAWING NO.		REV. A		
		77	04016		SHEET 1 OF 2		
APPROVED APPR.		140.	BASKET HINGE		SCALE		
		4			NTS		
DATE	10.0	1.29	COPYRIGHT IS 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PREMITE AND COMPREMENTAL AND IS SUPPLIED ON THE EMPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY TAMPOSTS ON CONCENDED ON COMMUNICATED TO MAY OTHER PERSON WITHOUT				

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С



D4016-1 HINGE HALF, BASE

GRAIN DIRECTION 0.88 0.13 0.250 0.50 R0.03 0.13 --- 0.563 --R0.31 REF 0.63 Ø0.257 THRU

> D4016-3 HINGE HALF, LID **D4016-5 HINGE HALF, LIGHT LID**

NOTES: 1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M304B -5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR, PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221

2) FINISH: NONE

Α

REF DART SPEC M6061T6B 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT -1: 0.09 lbs

8

-3: 0.04 lbs -5: 0.01 lbs

CHECKED DRAWING NO. MFG. APPR. APPROVED

D4016 TITLE

REV. A SHEET 2 OF 2 SCALE

DE APPR. DATE 10.01.29

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3

DESIGN

DRAWN

AJS

AJS

NTS

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

BASKET HINGE